

Work Order ID 102546

102546

Page 1

Item ID: 646.9711

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 30/05/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/06/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Ref 13.05.30

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.625"

114 13/05/30 40 45 0

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB135

DWG REV: *UIC*

FOLIO REV: *AA*

offe 203-06-03 40 5
114 13/06/05

2- deburr and break all sharp edges except otherwise noted

102546

May-30-13 10:01:47 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 30/05/2013 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 02/06/2013 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Ofe 2013-06-03

MH 13/06/05

40 2

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

PD 13/06/06

40 0

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 20103

CA 13106106 YC

Work Order ID 102546

May-30-13 10:01:47 AM

102546

Page 3

Item ID: 646.9711

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Blade

Stop ***NS2***

Start Date: 30/05/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/06/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: _____								

N/A testing

204445

43/4/11 (40)

Work Order ID 102546***102546***

Page 4

Item ID: 646.9711

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 30/05/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/06/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

*shipped to
April**MLJ 13-06-11**MLJ 3-06-11*

Picklist Print

May-30-13 10:01:30 AM

Page 1

Work Order ID: 102546

Parent Item: 646.9711

Parent Item Name: Blade

Start Date: 30/05/2013

Required Date: 02/06/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	50.4411	0.386	16.252632			

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

MAT009

123250

- 125350

Loc Qty

50.4411001

0.0000001

50.4411

Loc Code

NH B/05/30

16.25

+ 1.93

JFE

2013-06-06

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03838				SHEET 1 OF 1	
	DWG NO. 646.9700	REV: NC	PREPARED BY B. PETERS	DATE: 04/01/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: CUTTER SUB ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>David Barker</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED NOTES.				ECR: D-13-030	

IS

2

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
~~PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX~~

w/b 102546

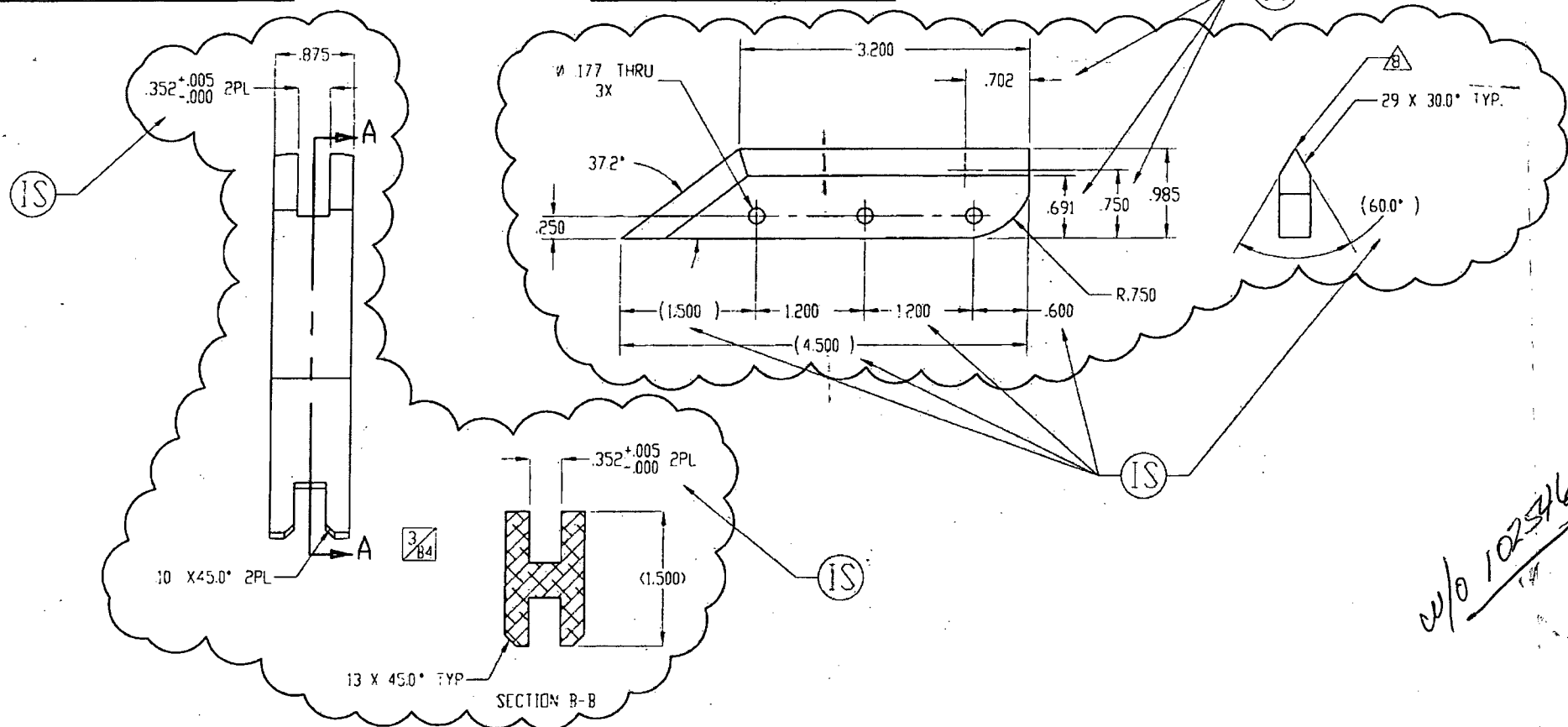
SHEET 1, NOTES IS:

DOCUMENTS EFFECTED:	<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
---------------------	--	---	--

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02744		SHEET 1 OF 1	
	DWG NO. 646.9700	REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10
	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.			
DWG TITLE: CUTTER SUB ASSY				
APPROVED BY: ENGR <i>[Signature]</i>	MEG <i>[Signature]</i>	GC <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH, CHANNEL WIDTHS & DIMENSIONING SCHEME SHEET 5.			

SHEET 2, ZONE C6, IS:

SHEET 5, ZONE C2, IS:



3	R	601.3157	12	SCREW	MS27039-0818
			.9701		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM				<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03838				SHEET 1 OF 1	
	DWG NO. 646.9700	REV: NC	PREPARED BY B. PETERS	DATE: 04/01/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: CUTTER SUB ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>David Barber</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED NOTES.			ECR: D-13-030	

IS

2

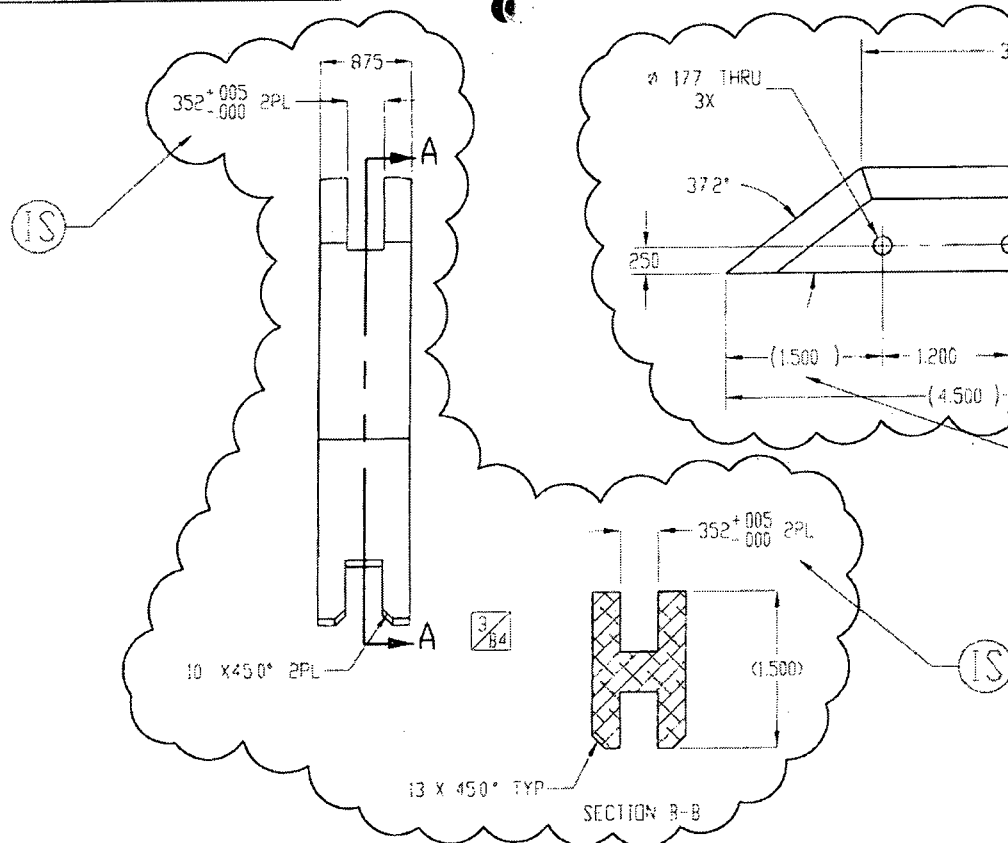
FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
~~PRIME IAW MIL-P-23377~~ J TYPE I CLASS N; 1-2 MIL MAX

SHEET 1, NOTES IS:

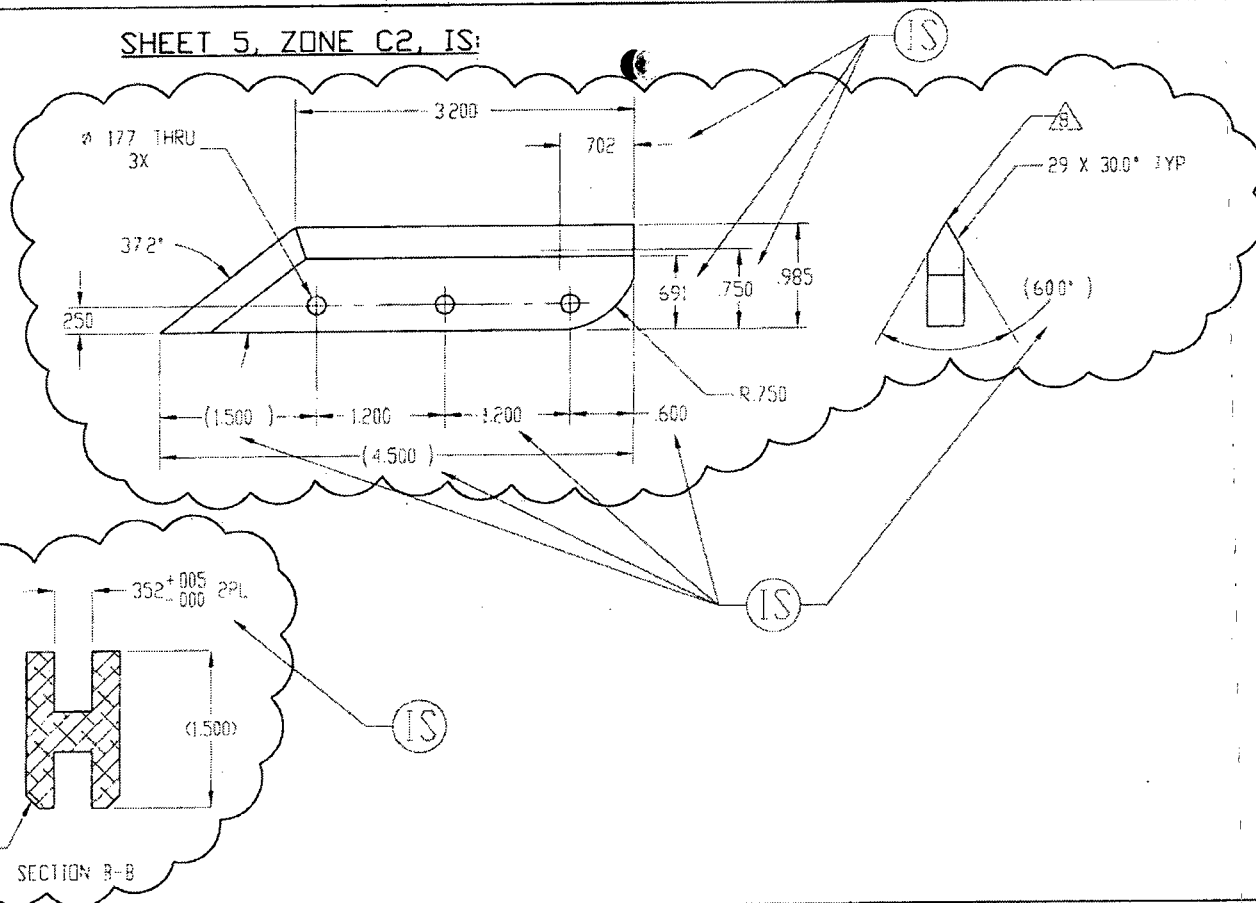
DOCUMENTS EFFECTED:	<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02744				SHEET 1 OF 1	
	DWG NO. 646.9700	REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: CUTTER SUB ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH, CHANNEL WIDTHS & DIMENSIONING SCHEME SHEET 5.					

SHEET 2, ZONE C6, IS:



SHEET 5, ZONE C2, IS:



3	R	601.3157	12	SCREW	MS27039-0818
			.9701		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM				<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES, INC. AND IS TO BE USED ONLY FOR THE PART OR PARTS IDENTIFIED HEREIN. THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS REQUIRED.

.340^{+.000}
-.005

Ø.177 THRU
3X

37.2°

.250

1.500

1.200

2.400

3.200

4.500

.500

.985

R.750

646.9711

8

.29 X 30.0° TYP.

ORIGINAL DATE REVISED DATE DESIGNED BY DRAWN BY CHECKED BY APPROVED BY DATE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
TITLE PART NO. SCALE		CUTTER SUB ASSY 646.9700 SCALE: NONE	
BY DATE CHECKED BY DATE		SHEET 3 OF 5	

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: ☒ Yes / No

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>102546</u> Part No. <u>646.9711</u> NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
<div style="display: flex; flex-direction: column; gap: 2px;"> <div><input type="checkbox"/> Doc/Data</div> <div><input type="checkbox"/> Equip/Tooling</div> <div><input checked="" type="checkbox"/> Operator</div> <div><input type="checkbox"/> Material</div> <div><input type="checkbox"/> Setup</div> <div><input type="checkbox"/> Other</div> <div><input type="checkbox"/> Process</div> <div><input type="checkbox"/> Supplier</div> <div><input type="checkbox"/> Training</div> <div><input type="checkbox"/> Unapproved</div> </div>	<u>13/06/05</u>	<u>110</u>	<u>5</u>	Part lifted out of vice and caused undersize. R.C. operator Error	<u>DAS 16</u> <u>9-23</u> <u>Q72042</u> <u>13/06/06</u>	Scrap & destroy	<u>MH</u> <u>13/06/05</u>	<u>PO</u> <u>13/06/06</u>	<u>DAS 16</u> <u>9-23</u> <u>Q72042</u> <u>13/06/06</u>

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions														
<table style="width:100%; font-size: small;"> <tr> <td><input type="checkbox"/> Ovalized</td> <td><input type="checkbox"/> Pressure/Forced</td> </tr> <tr> <td><input checked="" type="checkbox"/> Over/Under tolerance</td> <td><input type="checkbox"/> Temperature/Cure</td> </tr> <tr> <td><input type="checkbox"/> Part Incorrect</td> <td><input type="checkbox"/> Weld</td> </tr> <tr> <td><input type="checkbox"/> Part Lost/Missing</td> <td><input type="checkbox"/> Wrong Stock Pulled</td> </tr> <tr> <td><input checked="" type="checkbox"/> Part Moved</td> <td></td> </tr> <tr> <td><input type="checkbox"/> Positioned Wrong</td> <td></td> </tr> <tr> <td><input type="checkbox"/> Power Loss/Surge</td> <td><input type="checkbox"/> Other</td> </tr> </table>			<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced	<input checked="" type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled	<input checked="" type="checkbox"/> Part Moved		<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other
<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced															
<input checked="" type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure															
<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld															
<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled															
<input checked="" type="checkbox"/> Part Moved																
<input type="checkbox"/> Positioned Wrong																
<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other															



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20103

Purchase Order Date 6/6/2013

PO Print Date 6/7/2013

Page Number 1 of 2

Order From :

VC-MET004

METCOR INC.

560 BOUL. ARTHUR SAUVE

SAINT-EUSTACHE, QC J7R 5A8

CA

Contact Name

Vendor Phone

450 473 1884

Vendor Fax

450 491 5498

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FAKED
02/30/00

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	102546	646.9711 BLADE	6/14/2013 Yes	40.00	FedEx PI collect	\$5.4000	\$216.00
Special Notes: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED							
2	102546	DETAIL C OF C	6/14/2013 Yes	1.00	FedEx PI collect	\$48.0000	\$48.00
3	97924	D4456-2 RAINGUTTER	6/14/2013 Yes	10.00	FedEx PI collect	\$30.0000	\$300.00

Change Nbr: 2

Change Date: 6/7/2013

No substitution or deviation without
consent.
Certificate of Conformity of Material
Certification required **YES** NO

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
186982	1	72262

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
PO20103		A2	2013/6/7	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

40 646.9711

(40) BLADE

REFERENCE 102546

TO 58-62 RC

MATERIAL: A2

11,

CONTENANT: 1 BOÎTE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 11,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 11,00

Signature:

Date:



Metcor Inc.

560, boul. Arthur-Sauvé, St-Eustache (Québec) J7R 5A8
Tél. 450 473-1884
Télécopieur/Fax administration 450 491-5498
Télécopieur/Fax production 450 491-6454

Page 2 / 2

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
186982	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO20103		A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	40	59.0 - 61.0 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	11	646.9711 (40) BLADE REFERENCE 102546 TO 58-62 RC MATERIAL: A2 CONTENANT: 1 BOÎTE DE CARTON

COMMENTAIRES / comments

CERTIFIÉ par / Certified by:

METCOR

DATE: 2013-06-10

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ

ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
186982	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO20103		A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	40	59.0 - 61.0 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	11	646.9711 (40) BLADE REFERENCE 102546 TO 58-62 RC MATERIAL: A2 CONTENANT: 1 BOÎTE DE CARTON

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 PREHEAT 1	1200	0:30	VAC			393				
4.00 PREHEAT 2	1500	0:30	VAC			393				
5.00 VAC HARDE	1800	1 hrs 30 minutes	VAC		AZOTE	393				
6.00 TEMPER	400+/-10°F	2 hrs	air			617				
7.00 TEMPER 2	400+/-10°F	2 hrs	air			617				

